

Date: Tuesday, 22/04/2008 10:27:03 AM  
 User: Jean-Luc Menard

## Process Sheet

D205-778

|                       |                                  |                  |                              |
|-----------------------|----------------------------------|------------------|------------------------------|
| Customer              | : CC-DAR01 Dart Aerospace Ltd.   | Drawing Name     | : INITIAL PROTOTYPE TEMPLATE |
| Job Number            | : 00075A                         |                  |                              |
| Estimate Number       | : 10068                          |                  |                              |
| P.O. Number           | :                                | Part Number      | : INITIAL PROTOTYPE          |
| This Issue            | : 22/04/2008 S.O. No. :          | Drawing Number   | :                            |
| Prsht Rev.            | : NC                             | Project Number   | : AS0001                     |
| First Issue           | : 19/09/2006 Type : R & D LG FAB | Drawing Revision | :                            |
| Previous Run          | : 00074A                         | Material         | :                            |
| Written By            | : <u>22/08.04.18</u>             | Due Date         | : 12/09/2006 Qty: 1 Um: Each |
| Checked & Approved By | :                                |                  |                              |
| Comment               | : Project # <u>00075</u>         |                  |                              |
|                       | Description: _____               |                  |                              |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                 |                 |
|-----|-----------------|-----------------|
| 1.0 | MFG ENGINEERING | MFG ENGINEERING |
|-----|-----------------|-----------------|



Comment: MFG ENGINEERING

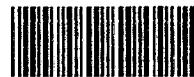
Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

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|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

X



Comment: FLOW WATER JET

cut d3777-1

B 8-4-22

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00075A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

3.0 M304S22GA 304/316 .032 Sheet



Comment: Qty.: 0.0180 sf(s)/Unit Total : 0.0180 sf(s)  
304/316 .032 Sheet for d3777-1  
Batch: 106419 HB 8-4-22

4.0 PG PURCHASING



Comment: PURCHASING  
Attached certificate of conformity for raw material and subcomponents use for this w/o

5.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Extrusion

6.0 D2808 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spacer

7.0 D33951 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bushing

8.0 MS20600AD4W5 Blind Rivet



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)  
Blind Rivet

9.0 MS21919WDG8 Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Clamp

10.0 D35921 Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
BRACKET

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00075A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D35601

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
ARM

12.0

D35603

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
ARM

13.0

D2808

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spacer

N/A of 08.04.14

14.0

D35602

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
ARM

15.0

D35604

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
ARM

16.0

D35921

Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BRACKET

17.0

CR3213405

cherry rivet



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)  
cherry rivet

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
cut per drwg D3388 REV.8  
85.15"

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00075A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
TACK WELD PROTO ARMS AS PER DRWG

N/A CP 08.05.14

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING  
Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

ENG USE CP 08.05.14

21.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: ENGINEERING RESOURCE #1  
Approval of project manager

CP 08.05.14

22.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

08/05/15

23.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Job Completion



W 08/05/14

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D205-778

Job #: 00075

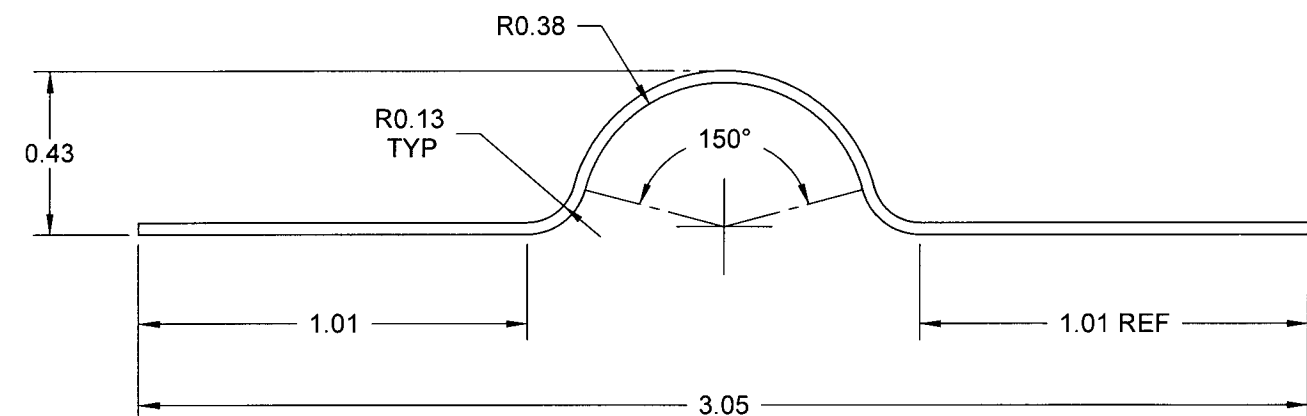
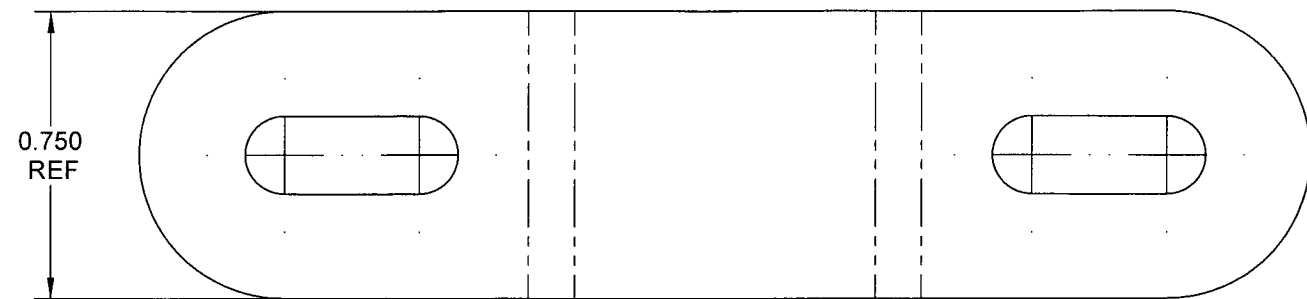
Date: 08.04.021

Product Name: Comfort Seat

Requested By: CP

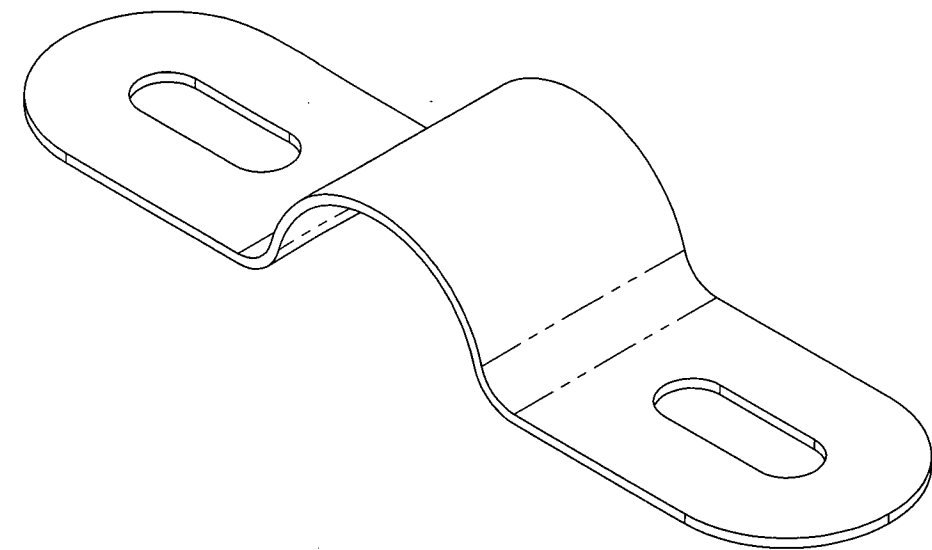
Design Manager Approval: 

| Quantity | Part Number | Description | Drawing Date | Material Cert Req'd? | Due Date | Comments                     | Date Completed |
|----------|-------------|-------------|--------------|----------------------|----------|------------------------------|----------------|
| 1        | D3777-1     | Clamp       | 08.04.21     | N                    | 08.04.24 | Need qty(1) for test fitting |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |
|          |             |             |              |                      |          |                              |                |



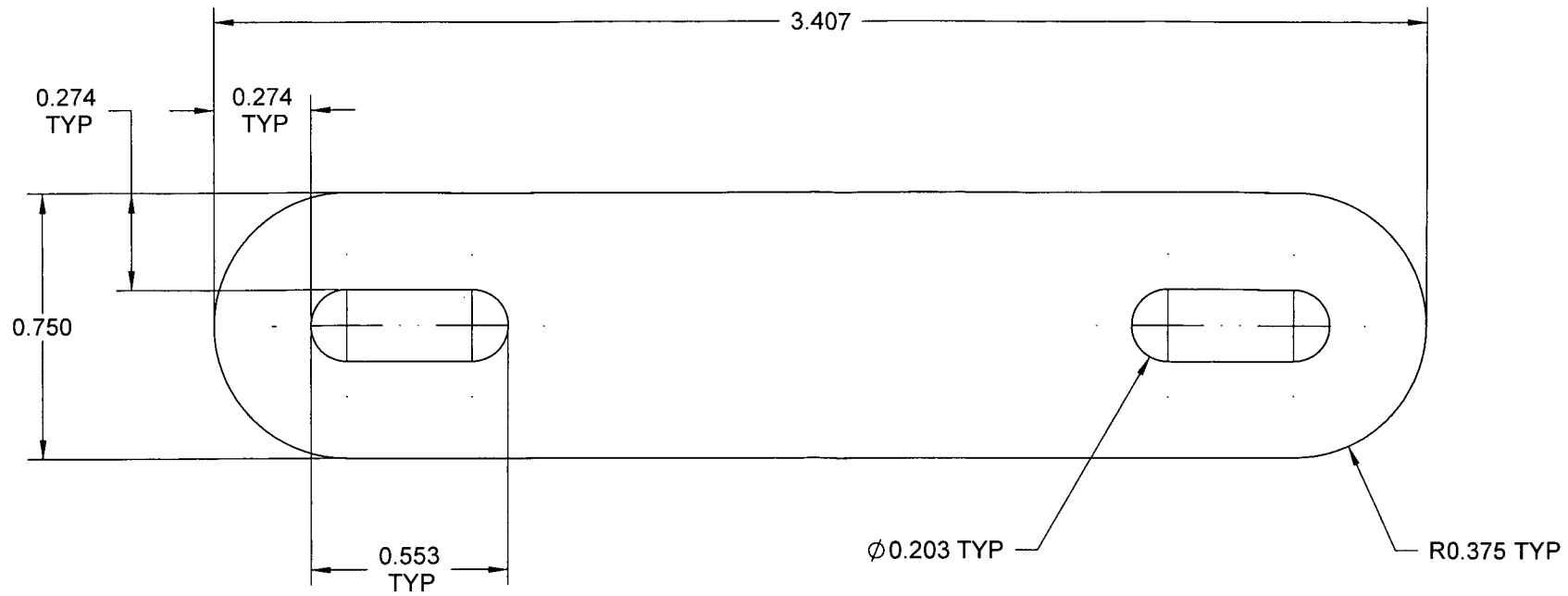
**D3777-1 CLAMP**

- NOTES:
- 1) MATERIAL: MAKE FROM D3777-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs



**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
0804.21

|   |             |    |          |
|---|-------------|----|----------|
| A   | New Issue   | CP | 08.04.08 |
| REV.  | DESCRIPTION | BY | DATE     |
| DESIGN  |             |    |          |
| DRAWN   |             |    |          |
| CHECKED   |             |    |          |
| MFG. APPR.  |             |    |          |
| APPROVED  |             |    |          |
| DE APPR.  |             |    |          |
| DATE  | 08.04.08    |    |          |
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3777</b><br>REV. A<br>SHEET 1 OF 2<br>TITLE <b>CLAMP</b><br>SCALE 1:1<br>COPYRIGHT © 2008 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |             |    |          |



**D3777-1F CLAMP**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
08.04.21 97

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.031 THICK (REF DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs

|            |                 |  |              |
|------------|-----------------|--|--------------|
| DESIGN     |                 | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | <i>DP</i>       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |                 | DRAWING NO.  | REV. A       |
| MFG. APPR. |                 | <b>D3777</b>   | SHEET 2 OF 2 |
| APPROVED   |                 | TITLE  | SCALE        |
| DE APPR.   |                 | <b>CLAMP</b>   | 2:1          |
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